

# Work Order ID 60368

July 6, 2010 2:57:37 PM



Page 1

Item ID: D3782-045

Accept



Setup Start



Revision ID:

Item Name: Back Leg Assembly

Stop



Start Date: 7/06/10

Start Qty: ~~6.00~~ <sup>07</sup>



Cust Item ID:

Required Date: 7/20/10

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: CZ

Date: 10/7/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3782

Rev B

100

Pick Kit

0.00



Packaging

Memo

0.00

SB 10/07/23

7

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

SB 10/07/23

7

Small Fab

1-assemble as per dwg D3782

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S 10/07/23

7

Quality Control

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60368

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Page 2

Item ID: D3782-045

Accept



Setup Start



Revision ID:

Item Name: Back Leg Assembly

Stop



Start Date: 7/06/10 Start Qty: 6.00



Required Date: 7/20/10 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location 256

0.00



Packaging

Memo

0.00

Packaging

10-8-23 7.29

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/26 MF

10-7-23

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 60368

Parent Item: D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 7/06/10

Required Date: 7/20/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec  
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C  
10.02.22 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3772-1 Back Leg		Manufactured	No			110	Each	15.0000	1	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST254				15					
				54341				12					
				54374 B 56860				3					
D3787-1 Foot		Manufactured	No			110	Each	34.0000	1	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST249A				34					
				46597				2					
				55763				32					
D3764-1 Back Leg Fitting		Manufactured	No			110	Each	10.0000	1	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST248A				10					
				54340				10					
D3773-041 Headrest Assembly		Manufactured	No			110	Each	1.0000	1	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST249				1					
				57448				1					

B 60384

SB 10/07/23

SB 10/07/23

SB 10/07/23

SB 10/07/23

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 60368

Parent Item: D3782-045

Parent Item Name: Back Leg Assembly



Start Date: 7/06/10

Required Date: 7/20/10

Start Qty: 6.00

Required Qty: 6.00

D3786-1



Sleeve

Manufactured No

110 Each

7.0000

1

6



## Location

## Loc Qty

## Loc Code

ST248A

3

44533

3

ST249A

4

59224

4

3

4

6

SB 10/07/03

AN45-15A



EYE BOLT

Purchased No

110 Each

20.0000

1



## Location

## Loc Qty

## Loc Code

ST362

20

109091

10

114523

10

107

6

SB 10/07/03

AN5-15A



Bolt

Purchased No

110 Each

64.0000

1



## Location

## Loc Qty

## Loc Code

ST338

64

114941

64

107

6

SB 10/07/03

AN5-17A



Bolt

Purchased No

110 Each

127.0000

1



## Location

## Loc Qty

## Loc Code

ST339

127

114330

81

114784

46

107

SB 10/07/03

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Shop Packet Print

Page 2

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 3

Work Order ID: 60368

Parent Item: D3782-045

Parent Item Name: Back Leg Assembly



Start Date: 7/06/10

Required Date: 7/20/10

Start Qty: 6.00

Required Qty: 6.00

AN4-15A

Purchased No

110 Each

391.0000 2 12



Bolt

Location

Loc Qty

Loc Code

ST358

391

114784

91

115108

300

110 Each

4,422.000 2 12

MS21042L4

Purchased No



Nut

Location

Loc Qty

Loc Code

ST300

4410

113422

68

114523

28

114718

314

114784

2000

115108

2000

ST356

12

108145

12

110 Each

463.0000 3 18

MS21042L5

Purchased No



Nut

Location

Loc Qty

Loc Code

ST139

463

114813

463

110 Each

20.0000 4 24

AN960JD416

NAS1149D0463J Purchased

No



Washer

Location

Loc Qty

Loc Code

ST351

20

108827

20

1115000

20

SB 10/07/23

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Page 3

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

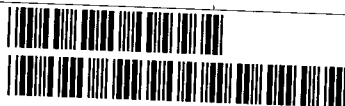
July 6, 2010 2:57:37 PM

Page 4

Work Order ID: 60368

Parent Item: D3782-045

Parent Item Name: Back Leg Assembly



AN960JD516

NAS1149D0563J Purchased

No



Washer

Start Date: 7/06/10

Required Date: 7/20/10

Start Qty: 6.00

Required Qty: 6.00

110

Each

0.0000

5

30

M 114742



35

SB

10/28/23

July 6, 2010 2:57:37 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

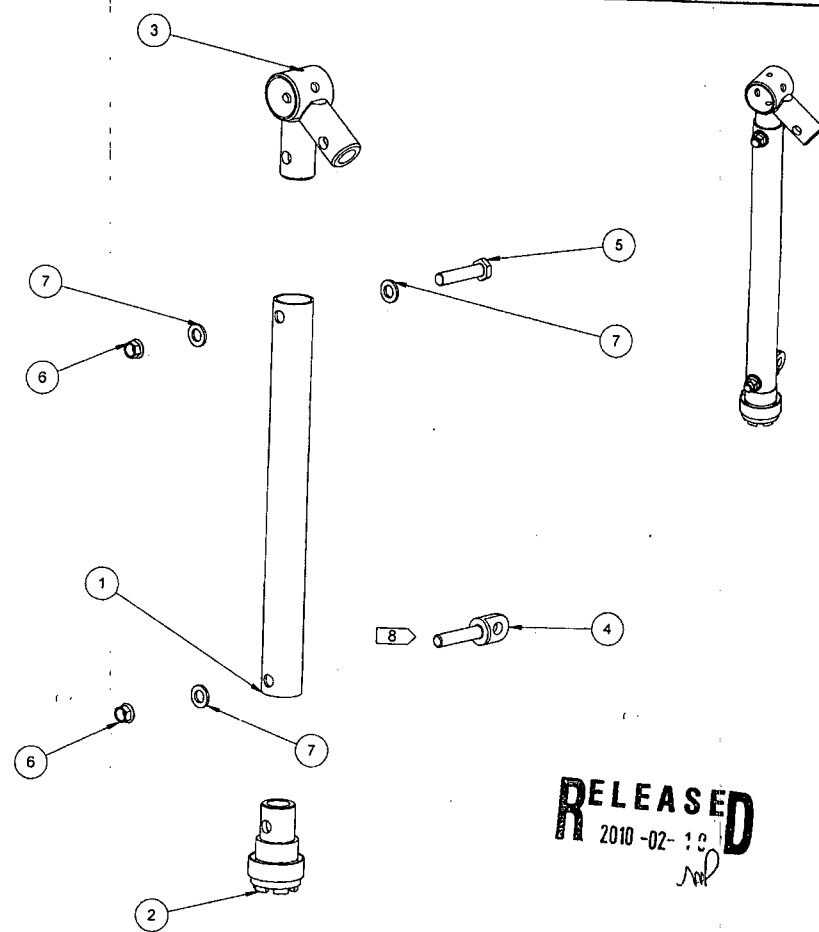
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM NO.	QTY. (-041)	PART NUMBER	DESCRIPTION
1	1	D3768-1	FRONT INBOARD LEG
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	1	AN45-13A	EYE BOLT
5	1	AN5-13A	BOLT
6	2	MS21042L5	NUT
7	3	NAS1149D0563J	WASHER (AN960JD516)

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WORK ORDER  
NO. 60368

CZ101716



# **D3782-041 FRONT INBOARD LEG ASSEMBLY**

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.42 lbs  
8) ITEM 4 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH  
INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH

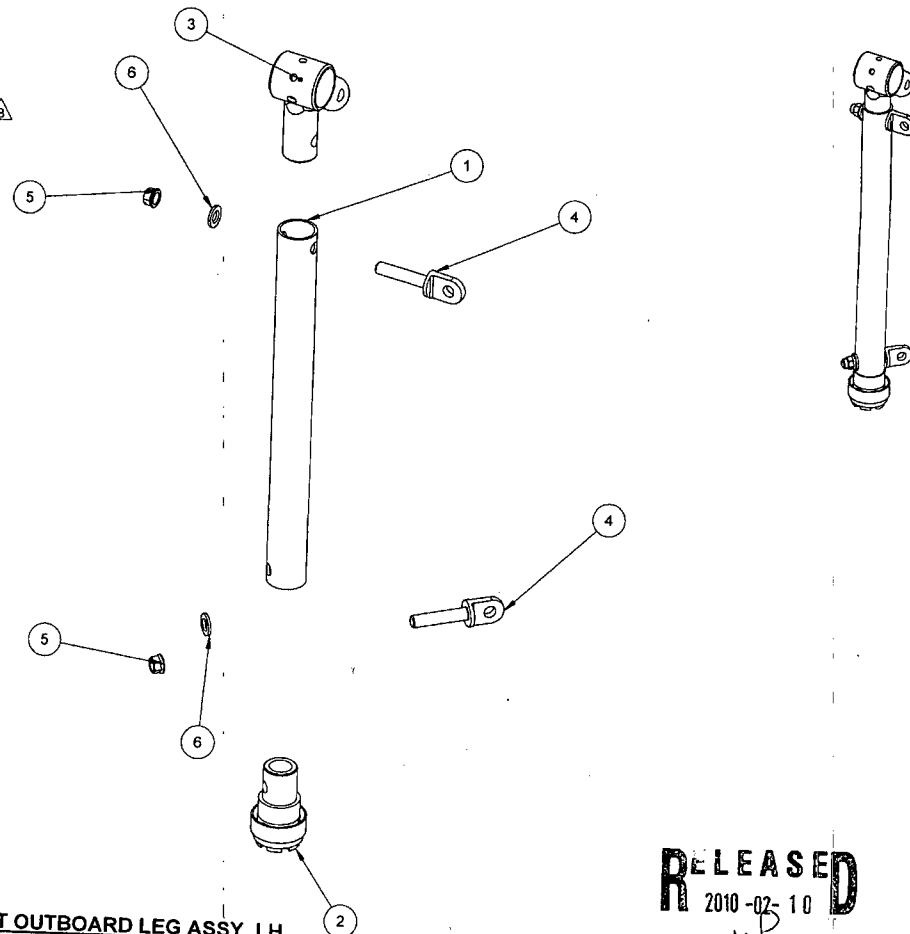
**RELEASED**  
2010-02-10

B	REVISE P/N NAS1149D0568J TO NAS1149D0563J ALL SHEETS, ZN D7	HS	10.01.21
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B	
DRAWING NO. D3782		SHEET 1 OF 4	
TITLE LEG ASSEMBLY		SCALE NTS	
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ITEM NO.	QTY. (-043)	PART NUMBER	DESCRIPTION
1	1	D3788-3	FRONT OUTBOARD LEG, LH
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)

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WORK ORDER  
NO. 60368

D3782-043 FRONT OUTBOARD LEG ASSY, LH



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

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2010-02-10  
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CHECKED	1	DRAWING NO.	REV. B
MFG. APPR.	1	D3782	SHEET 2 OF 4
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DE APPR.	1	LEG ASSEMBLY	NTS
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ITEM NO.	QTY. (-044)	PART NUMBER	DESCRIPTION
1	1	D3768-4	FRONT OUTBOARD LEG, RH
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)

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NO. 60368

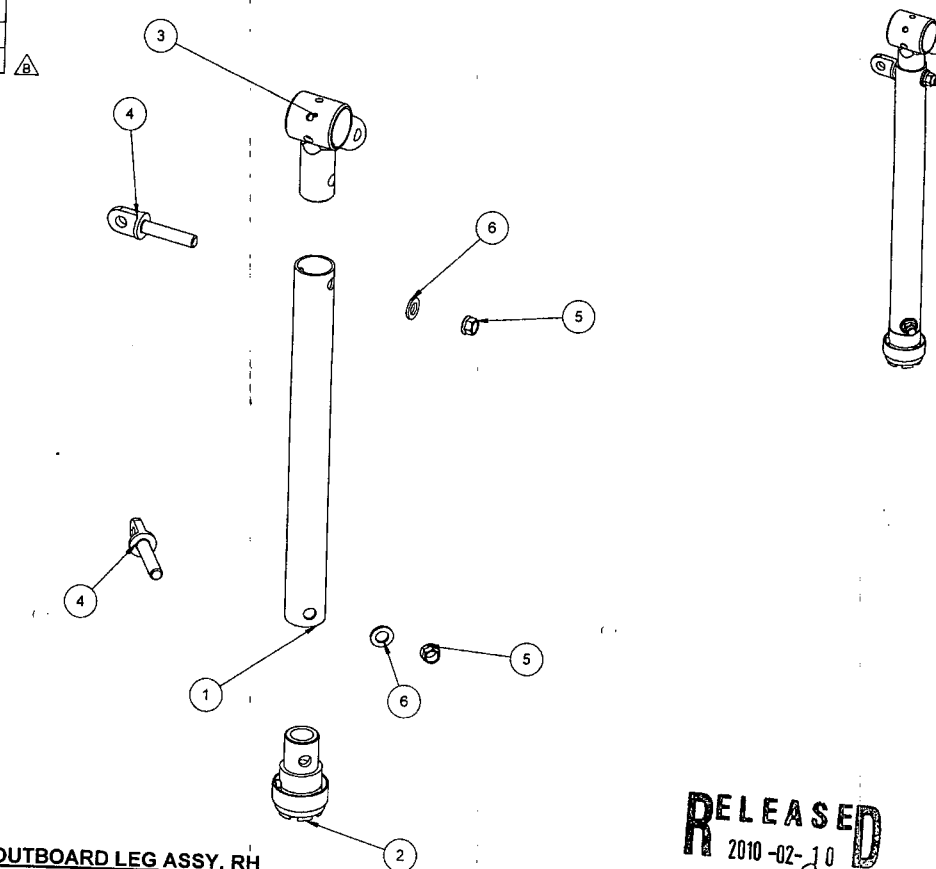
**D3782-044 FRONT OUTBOARD LEG ASSY, RH**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. <b>D3782</b>
MFG. APPR.		REV. B
APPROVED		SHEET 3 OF 4
DE APPR.		TITLE <b>LEG ASSEMBLY</b>
DATE	<b>10.01.21</b>	SCALE NTS

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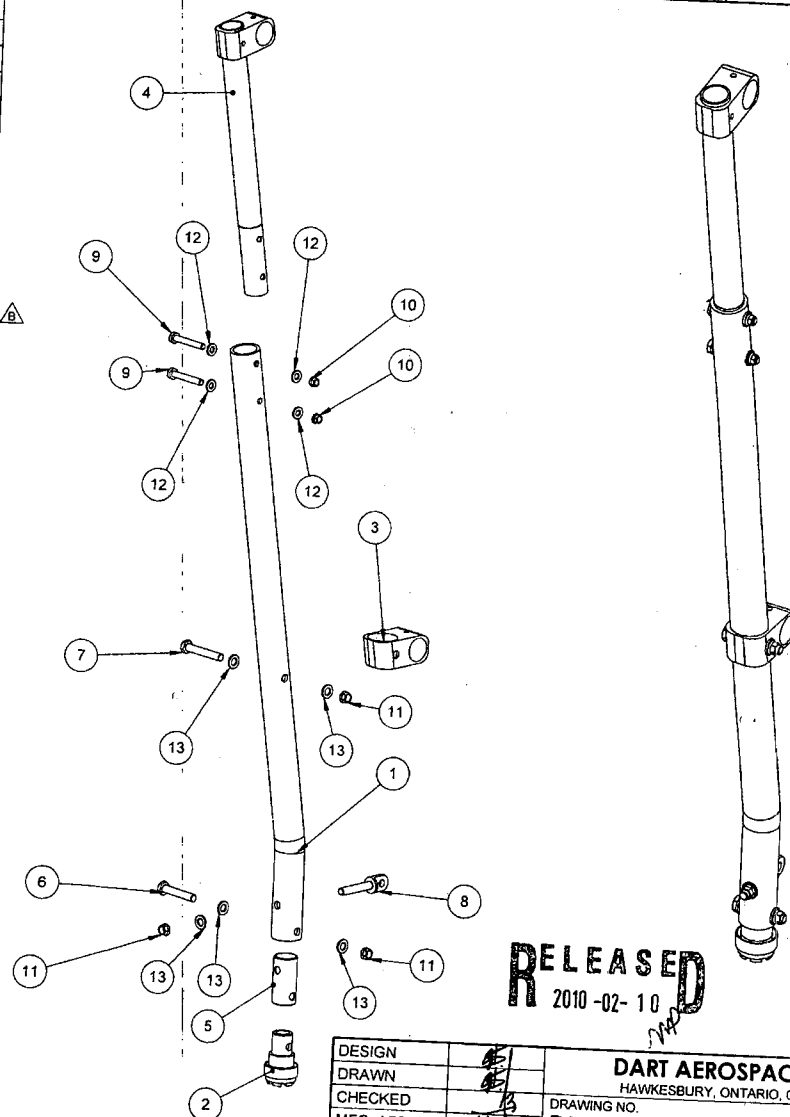
ITEM NO.	QTY. (-045)	PART NUMBER	DESCRIPTION
1	1	D3772-1	BACK LEG
2	1	D3787-1	FOOT
3	1	D3764-1	BACK LEG FITTING
4	1	D3773-041	HEAD REST ADAPTER ASSY
5	1	D3786-1	SLEEVE
6	1	AN5-15A	BOLT
7	1	AN5-17A	BOLT
8	1	AN45-15A	EYE BOLT
9	2	AN4-15A	BOLT
10	2	MS21042L4	NUT
11	3	MS21042L5	NUT
12	4	NAS1149D0463J	WASHER (AN960JD416)
13	5	NAS1149D0563J	WASHER (AN960JD516)

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WORK ORDER  
NO. 60368

**D3782-045 BACK LEG ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.71 lbs



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2010-02-10

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3782	SHEET 4 OF 4
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